Work Order Wednesday, Octob													Page 1
Revision ID: Item Name:	O3492-11 Plug O/5/2011	Start Qty: 20.00	1180/8 //0/ 80/	Accept	Cust	tem ID:	·			Setup	Start Stop		818 18 18 18 18 18 18 18
Required Date: 1 Reference:	0/14/2011	Req'd Qty: 20.00			Custo	mer:							
	Process Plan	n:	Date:////0-5	Tooling: SPC (Y/N):		_ Date				Run	Start Stop	1 8 8 1 8 1	8 8 8 8 8
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool	ID '	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr											
D3492	D												4
		Hardinge CNC LATHE	E SMALL	0.00					20	E)	art	Stillolz
Hardinge Hardinge CNC Lathe	Small	Memo 1-Turn as Dwg Rev: Folio Rev:	per Folio FA714 & Dwg D34	0.00									-
110		QC2- Inspect parts off	machine FAI/FAIB	0.00					20	c	,	4	A whole
QC Quality Control		Мето		0.00									<u> </u>
120 		QC8- Inspect parts - se	cond check	0.00	n 11/10/2	1			2 .		/		
QC Quality Control		Memo		0.00	11/0/2	·f			20		\$		

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W/O:		•	WORK ORDER CHANGES									
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
			·									
•												
Part No) :	PAR #:	Fault Category:	NCR: Y	es No D C	PA:	Date: _					
	Resolutio	n:	Disposition:	QA: N/C	Closed: _		Date: _					
NCR:			WORK ORDER NON-COM	NFORMANCE (N	CR)							

NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCH)			
	T	Description of NC		Corrective Action Section B	}	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Initial Action Description Sign &		Section C	Chief Eng	QC Inspector
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1								

Work Order ID 74732

Wednesday, October 05, 2011 2:34:46 PM



Page 2

Item ID:

D3492-11

Accept

Setup Start



Revision ID:

Start Date:

Item Name:

Plug

Required Date: 10/14/2011

10/5/2011

Start Oty: 20.00

Req'd Qty: 20.00

Operation

Description



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling: SPC (Y/N): Date: _____

Date:

Run Start

Stop

Stop



Sequence ID/

Work Center ID

150

Hand Finishing

Memo

Chemical Conversion Coat per QSI005 4.1

Run Hours 0.00

Set Up/

Tool ID Tool # Plan

Accept Qty

Code

Reject Qty

Reject Number

Insp. Stamp

HandFinish

0.00

BL 11-10-08

160

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo (Flat End Only) START TIME:

OVEN TEMPERATURE

FINISH TIME:

170

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

20x d W 11/61

									
		WO	RK ORDER CHANG	GES					1
STEP	PRO	OCEDURE CHAN	IGE	By	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	PAR #·	Fault Cated	Orv:	NCB: V	es N	o DO.	۸.	Date:	
		_							
		WORK ORDE	R NON-CONFORM	ANCE (N	ICR)				
STEP	Description of NC Section A	Section A Initial Action De		cription Sign &		Section C		Approval Chief Eng	Approval QC Inspector
		Chief Eng	Chief Eng		ate			<u>.</u> .	
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		3							
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	Res	PAR #:PAR #:	STEP PROCEDURE CHAN PAR #: Fault Categ Resolution: Disposition WORK ORDE	STEP PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORM STEP Description of NC Section A Corrective Action Section A Corrective Action Description	PAR #: Fault Category: NCR: Y Resolution: Disposition: QA: N/O WORK ORDER NON-CONFORMANCE (NOTED) STEP Description of NC	STEP PROCEDURE CHANGE By PROCEDURE CHANGE By PAR #: Fault Category: NCR: Yes N. Resolution: Disposition: QA: N/C Clos WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date PAR #: Fault Category: NCR: Yes No DQA Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty PAR #: Fault Category: NCR: Yes No DQA: Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr

Work Order ID 74732

Wednesday, October 05, 2011 2:34:46 PM



Page 3

Item ID:

D3492-11

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 10/14/2011

Plug

10/5/2011

Start Qty: 20.00

Req'd Qty: 20.00 - - -

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

180

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location

Memo

Set Up/ Run Hours

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

190

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:			WC	ORK ORDER CHANG	GES				т
DATE	STEP	PRO	OCEDURE CHA		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
		solution:							
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (NCF	R)			
DATE	OTED	Description of NC			tion B	Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
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							····		
1									

Picklist Print

Wednesday, October 05, 2011 2:34:51 PM

Work Order ID: 74732

Parent Item: D3492-11

Parent Item Name: Plug

1 | 1841) | 1841 | 1841 | 1848 | 1844 | 1845 | 1 | 1841) | 1846 | 1841 | 1848 | 1848 | 1844 | 1845 | 1846 | 1846 | 1846 | 1846 | 1846 | 1846 | 1846 | 1846 |

Start Date: 10/5/2011

Required Date: 10/14/2011

Start Qty: 20.00 Required Qty: 20.00

Comments:

IPP Rev:A 11.04.19 per dwg revC DD verf:EC

- -	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.875		Purchased	No			100	f	9.4000	0.04	0.842105	· orty	1 11	Molad

6061-T6 Round Bar .875"

Dart Aerospace l	Ltd	
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W/O:			WO	RK ORDER CHANGE	S				y
DATE	STEP	PRO	CEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								Proa Mgr	
:	1								
									<u> </u>
Part No		PAR #:	*.		NCR: Yes	No DQA:		_ Date: _	
	R	esolution:	Disposition);	QA: N/C Clo	sed:		_ Date: _	
NCR:		* · . · . · . · . · . · . · . · . ·	WORK ORDE	R NON-CONFORMA	NCE (NCR)				
DATE	STEP	Description of NC		Corrective Action Section		Verifica	tion	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	С	Chief Eng	QC Inspector
								•	
						 			
		·							

DART AEROSPACE LTD	Work Order:	74732
Description: Plug	Part Number:	D3492-11
Inspection Dwg: D3492 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.850	+0.010/-0.001	00.851	\		SLUB	
Ø0.664	+0.008/-0.001	\$0.4655	1		SLOZ	
0.045	+0.000/-0.002	0.0435			Vi	
0.090	+0.000/-0.002	0.0885	1		61	
0.500	+/-0.010	0.501	V .		Vi.	
0.060	+/-0.005	0.060		-	11	
0.060	+/-0.005	0.063			f i	
0.050 x 20°	+/-0.010 x 0.5°	0.050 Y 20°	<i>\</i>		U	

<u>, , , , , , , , , , , , , , , , , , , </u>			1 32			
						,
				<u> </u>		

	11					
Measured by:	17	fort	Audited by:	J.A	Preliminary Approval:	
Date:	11/10	124	Date:	11/10/27	Date:	

Rev	Date	Change		Revise	d by		Approv	ved
Α	08.02.28	New Issue	P/O D3492-049	KJ/DD	10		//	1
В	11.06.21	Dwg Rev updated		KJ	W	7	/11	
					777			

	-								
W/O:			WO	RK ORDER CHANGE	S		31		
DATE	STEP	PRO	Ву	Date	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
	,					· · · · · · · · · · · · · · · · · · ·			
Part No	:		Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _	
*		*		QA: N/C Closed: Date:					
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCI	₹)			
DATE	OTED	Description of NC			В	Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	Section C	Chief Eng	QC Inspector
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l	1	1	1 1					i .	1

-NAS1611 O-RING (SEE TABLE) D3492-XX PLUG (SEE TABLE)-

D3492-XXX PLUG PARTS LIST

QTY -041	Q1Y -043	QTY -045	QTY -047	Q1Y -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			Х				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
-	ļ		ļ	ļ		ļ	004004	I DI LIG
	-	!	-			—-	D3492-1	PLUG
	1						D3492-3	PLUG
	L	1	L				D3492-5	PLUG
			1				D3492-7	PLUG
	<u> </u>			1	L		D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
	 	. 1					NAS1611-005	O-RING
		-	1				NAS1611-007	O-RING
1		<u> </u>					NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
	1		1	1			NAS1611-016	O-RING

NOTES:
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY **RETURN TO ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE

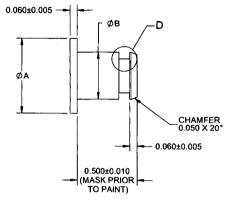
REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	PH	06.01.04
В	ADD -047; UPDATE DIM A FOR -045	PH	08.05.11
_ c	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24

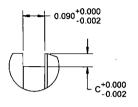
DESIGN	PH	DART AEROSPACE LTD				
DRAWN	AJS		INTARIO, CANADA			
CHECKED	ki	DRAWING NO.	REV. D			
MFG. APPR.	JEL	D3492	SHEET 1 OF 2			
APPROVED	VAK	TITLE	SCALE			
DE APPR.	7	PLUG	2:1			
DATE 11.	05.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD HIS DOCUMENT IS PRIVATE AND DISFERENTAL AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR NAY PURPOSES ON COPPED ON COMMANCE TOD TO ANY ORDER PRISON WITHOUT				

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W/O:			WC	RK ORDER CHANGE	S				
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector
					<u>.</u>				
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Part No	•	PAR #:	Fault Cateo	jory:	NCR: Yes	No DQ	A:	Date: _	
	Re	solution:	Disposition	ı:	QA: N/C C	losed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NCI	?)			
DATE	STEP	Description of NC	Corrective Action Section B			Verific	cation	Approval Chief Eng	Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	on Sign & Date		on C		QC inspector
						j			

POWDER COAT THESE FACES ONLY PER NOTE 2

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D

С

В

DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	В	С	MATERIAL SPEC	
D3492-1	0.625	0.394	0.050	M6061T6R0.625	
D3492-3	0.750	0.582	0.045	M6061T6R0.750	
D3492-5	0.375	0.188	0.045	M6061T6R0.375	
D3492-7	0.500	0.270	0.045	M6061T6R0.500	
D3492-9	0.938	0.750	0.045	M6061T6R1.000	
D3492-11	0.850	0.664	0.045	M6061T6R0.875 /	
D3492-13	0.750	0.510	0.045	M6061T6R0.750	-

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M60616R0.000)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: N/A

8

DESIGN PH		DART AEROSPACE LTD					
DRAWN	A.S	HAWKESBURY, ONTARIO, CANADA					
CHECKED	K.	DRAWING NO.	REV. D				
MFG. APPR.	JESA	D3492	SHEET 2 OF 2				
APPROVED	\MH	TITLE	SCALE				
DE APPR.	1-#	PLUG	4;1				
DATE 11.	05.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PREVIOUS AND CORP EMPIRED ON THE COPPERS CONDITION THAT IT IS 100 TO BE USED FOR HAT RUPPOSE OR COMMANDIATE TO MAY OTHER RESISON WITHOUT.					

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W/O:			WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No:		PAR #:	Fault Cate	QA:	Date: _							
	Res	solution:	Disposition	on:	QA: N/C	QA: N/C Closed: Date:						
NCR:		\	WORK ORE	ER NON-CONFORM	ANCE (NC	R)						
DATE	STEP Descrip	Description of NC	Description of NC Corrective Action Sec			Sign & Section C		n Approval	Approval			
		Section A	Initial Action Description Sig Chief Eng Chief Eng Da		ection C	Chief Eng	QC Inspector					
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